

Work Order ID 138993

138993

Page 1

Friday, November 13, 2015 11:37:41 AM

Item ID: D2957

Revision ID:

Item Name: Mounting Plate

Start Date: 11/27/2015 Start Qty: 600

Required Date: 11/27/2015 Req'd Qty: 600

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: NOV 17 2015 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2957	Rev B

100 0.00

100

BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks 10.500" long
1 blank makes 5 parts

0.00

6 φ 2015-12-9

110

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine as per folio FA042
Deburr

0.00

0.01

30 φ DAS 45
9-89
2015-12-11

120

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

0.00

30 φ DAS 45
9-89
2015-12-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

Work Order ID 138993

138993

Page 2

Friday, November 13, 2015 11:37:41 AM

Item ID: D2957

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Mounting Plate

Start Date: 11/27/2015 Start Qty: 6.00

6 30
6

Cust Item ID:

Required Date: 11/27/2015 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

DAS

14

9-89

15/12/14

150

Identify as per dwg & Stock Location: W4

0.00

150

Packaging

Memo

0.00

Packaging

*****STOCK IN BASKET CELL*****
LOCATION WA004

DEC 14 2015

DAS

24

9-89

30

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.01

Quality Control

DEC 14 2015

ML5

ML5 DEC 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																																																																					

Picklist Print

Friday, November 13, 2015 11:37:41 AM

Page 1

Work Order ID: 138993

138993

Parent Item: D2957

D2957

Parent Item Name: Mounting Plate

Start Date: 11/27/2015

Required Date: 11/27/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: C00.08.09New dwg rev B (mpp 2078)EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X01.25 0		Purchased		No		100	f	14.0000	0.175	1.105263			

M6061T6B0 500X01 250

21 15-12-9

6061-T6 Bar .500 x 1.25

Location

Loc Qty

Loc Code

MAT001

14

128457

2

m133511

12

5.3

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

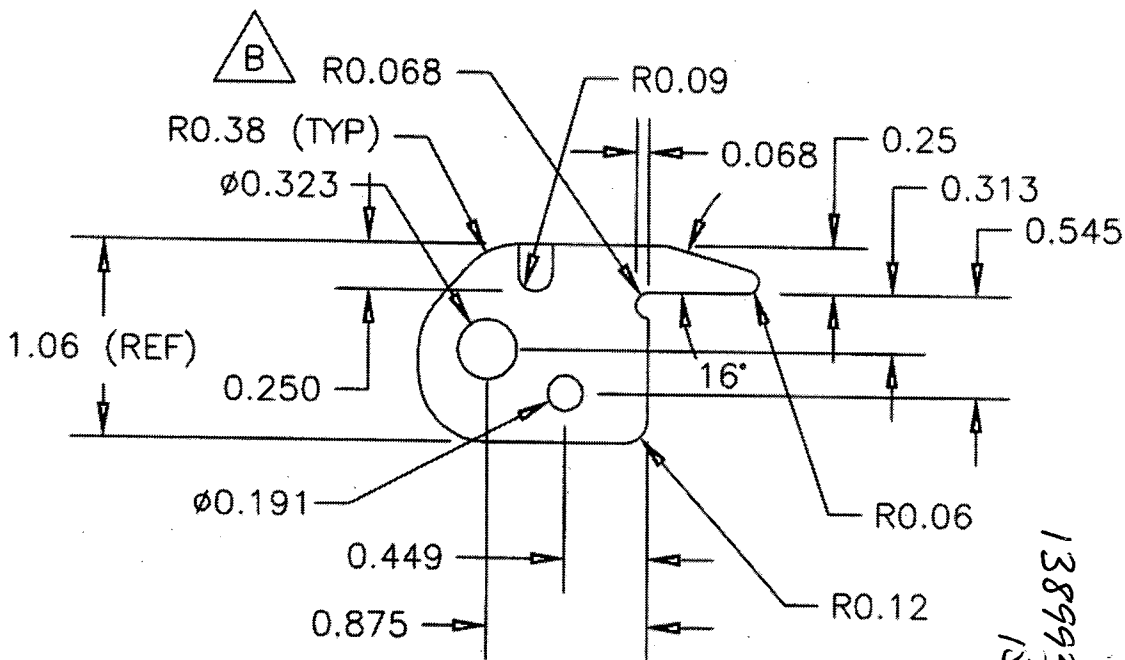
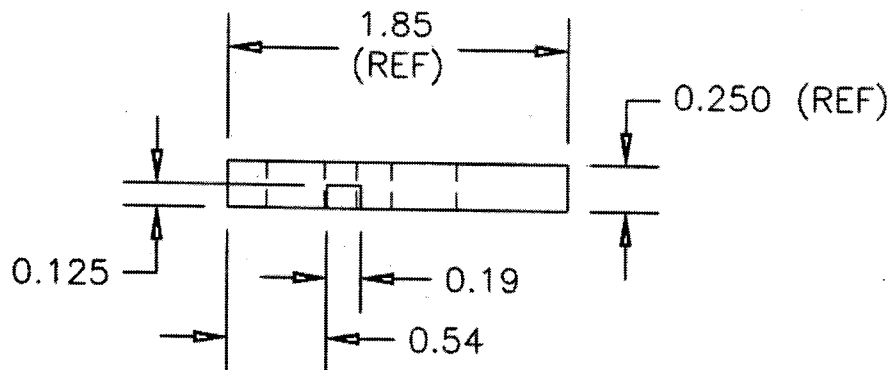
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2957	REV. B SHEET 1 OF 1
DATE 00.07.06		TITLE MOUNTING PLATE	SCALE 1:1
A	00.01.20	NEW ISSUE	
B	00.07.06	MODIFY CORNER DETAIL	

RELEASED
00.07.10 *[Signature]*



138993 MLS
15-11-17

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11) 0.250 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020

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